

Work Order ID 59956

Monday, June 21, 2010 7:53:13 AM



Page 1

Item ID: D3914-041

Accept



Setup

Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 6/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-6-21 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3914

A

100

Weld per dwg A/R S.S. rod Batch: *4113328* 0.00

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

***make sure to place mesh correctly on lid, check with label plate before
tacking mesh****SLY 10/06/23*

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

GC 10-07-07

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Required Date: 6/25/2010 Req'd Qty: 1.00



Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Evolution

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M 112588

0.00

Memo

*** mask sides of hinge prior to powdercoat***

Start Time: *1:20*

Oven Temperature: *320°*

Finish Time: *1:50*

Ø SK 10-7-7.

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

0.00

M114432

0.00

=> H1 10107107

Memo

✓1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

C 2- Install placard and label as per dwg

1 Ø

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Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

E50/67/08 ①

QC

Quality Control

Memo

0.00

160

Identify as per dwg & Stock Location: *6A*

Packaging

Packaging

afo 59954

0.00

E50/67/08 ①

Memo

0.00

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

100908

*MF
10-7-8*

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Picklist Print

Monday, June 21, 2010 7:53:12 AM

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Work Order ID: 59956



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/21/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2581



Mounting Bracket

Manufactured

No

100

Each

41.0000



B59121 (2)

10/06/22

Location

ST

Loc Qty

15

59121

Loc Qty

15

WA

Loc Qty

26

46086

Loc Qty

2

51745

Loc Qty

2

57185

Loc Qty

1

59265

Loc Qty

21

Manufactured

No

100

Each

4.0000



(2)

10/06/22

Location

WA

Loc Qty

4

59295

Loc Qty

4

Manufactured

No

100

Each

4.0000



(2)

10/06/22

Location

WA

Loc Qty

4

59095

Loc Qty

4

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Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/21/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4016-3



Hinge Half, Lid

Manufactured No

100 Each 13.0000



3 SM

10/06/22

Location	Loc Qty	Loc Code
----------	---------	----------

ST116	1	
-------	---	--

58243	1	
-------	---	--

WA	12	
----	----	--

58737	6	
-------	---	--

59744	6	
-------	---	--

✓ D4018-5



Rib

Manufactured No

100 Each 21.0000



9 SM

10/06/22

Location	Loc Qty	Loc Code
----------	---------	----------

WA	21	
----	----	--

58594	3	
-------	---	--

58669	18	
-------	----	--

✓ D4020-5



Mesh (350 Basket Long, Lid)

Manufactured No

100 Each 1.0000



1 SM

10/06/23

Location	Loc Qty	Loc Code
----------	---------	----------

WA	1	
----	---	--

59029	1	
-------	---	--

✓ D4021-3



Data Plate

Manufactured No

100 Each 4.0000



1 SM

10/06/22

Location	Loc Qty	Loc Code
----------	---------	----------

WA	4	
----	---	--

56050	1	
-------	---	--

59054	3	
-------	---	--

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Page 3

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Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/21/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041



Manufactured No

100

Each

0.0000

1

1



B59414① 88.10/06/22

Lid Rib Assembly, Fwd (350 Basket)

✓ D4035-043



Manufactured No

100

Each

2.0000

1

1



B59415① 84.10/06/22

Lid Rib Assembly, Aft (350 Basket)

D2728-3



Dart Logo label

D4086-210



Placard, Max Load

Location

Loc Qty

Loc Code

WA

2

59415

2

Manufactured No

140

Each

0.0000

1

1



M115050 (H)

Manufactured No

140

Each

10.0000

1

1



E510/07/08

E510/07/08

Location

Loc Qty

Loc Code

ST117

10

58926

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED 2010-03-22 *[Signature]*

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO. D3914	
MFG. APPR.	A	REV. A	
APPROVED	A	SHEET 1 OF 4	
DE APPR.	A	LONG BASKET LID ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

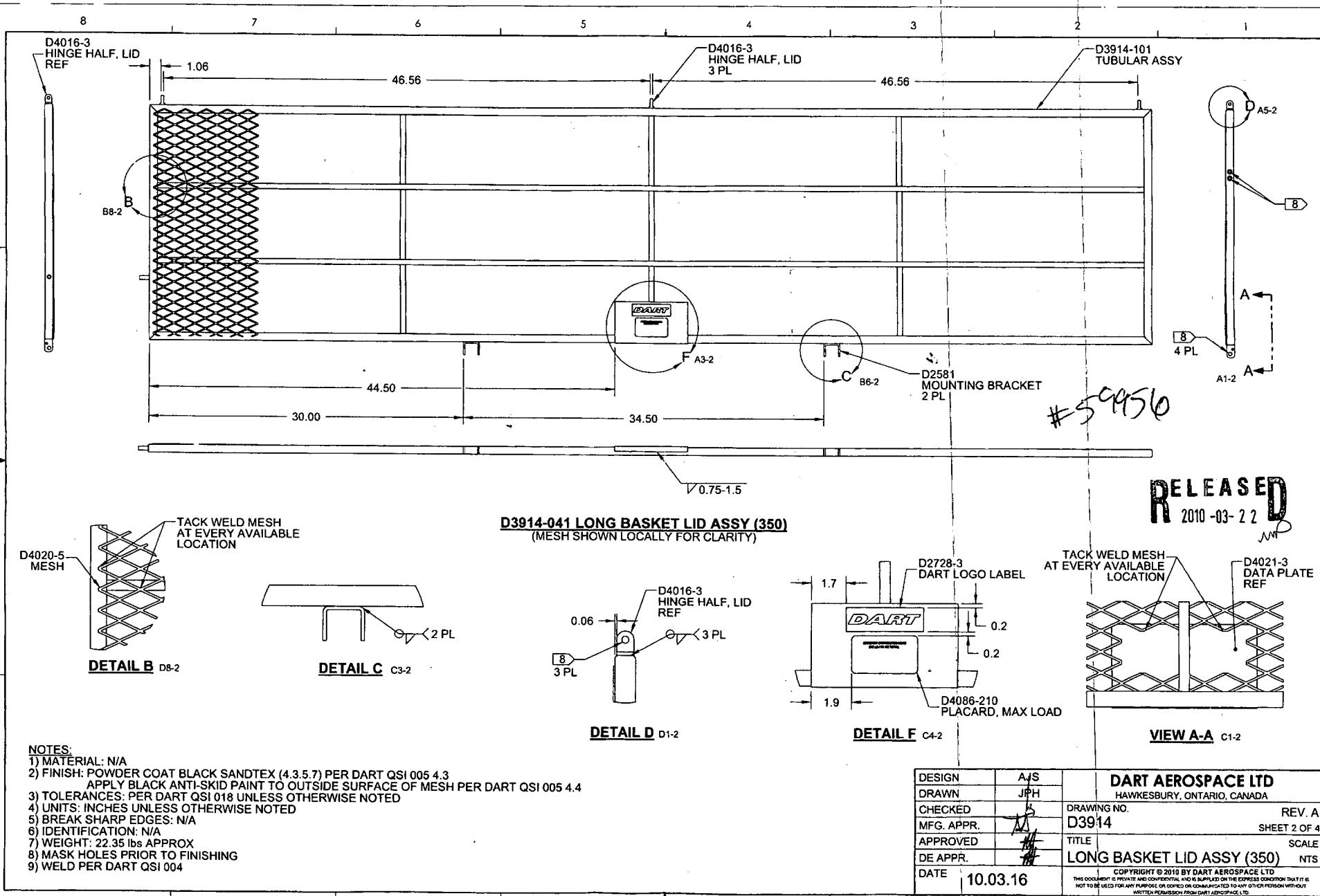
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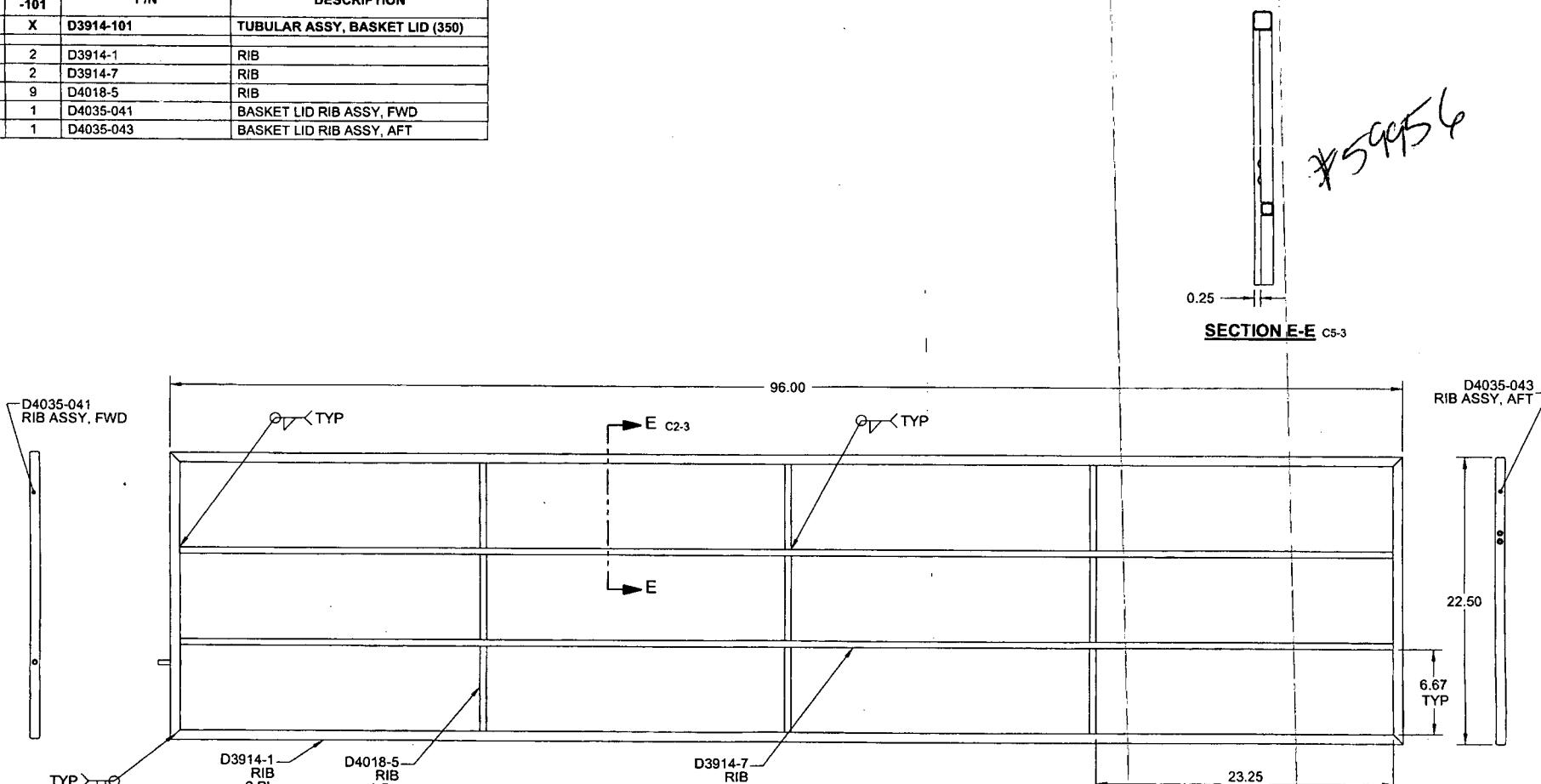
4

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1

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



RELEASED
2010-03-22
[Handwritten signature]

⑧ D3914-101 TUBULAR ASSY, LONG LID

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3914	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET LID ASSY (350) NTS	
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8

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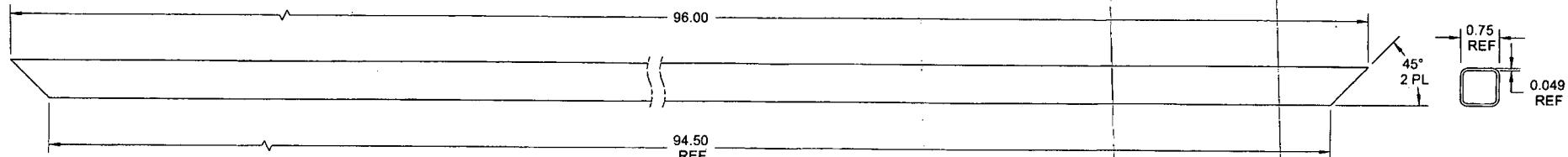
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1

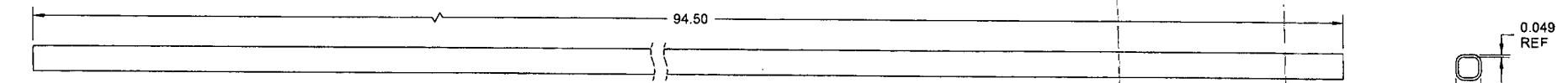
D

D



C

C



B

B

NOTES:

- 1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

8

7

6

5

4

3

2

1

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		SCALE
		LONG BASKET LID ASSY (350)
DATE	10.03.16	NTS

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